

Date: Tuesday, 21/11/2006 1:40:50 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LITTER DECKPLATE 350		
Job Number	: 29143		Part Number	: D2344		
Estimate Number	: 10357		Drawing Number	: D2344 REV.E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 21/11/2006	S.O. No. : <u>11A</u>	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 28/11/2006		
Previous Run	: 29143		Qty:	4	Um:	Each
Written By	: <u>Linda Lacelle</u>					
Checked & Approved By	: <u>Linda Lacelle</u>					
Comment	: Est Rev:D 00.06.26 Removed P/O for powder coat EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	M2024T3S063	2024-T3 .063 sheet		
Comment: Qty.: 0.7823 sf(s)/Unit Total : 3.1290 sf(s) Material: 2024-T3 QQ-A-250/5) .063 Batch <u>M101022</u> <u>ml 06 11 30</u> (4)				
2.0	WATER JET	FLOW WATER JET Prog Rev: <u>E</u> Dwg Rev: <u>E</u>		
Comment: FLOW WATER JET <u>ml 06 11 30</u> (4)				
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <u>ml 06 11 30</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  <u>ml 06 11 30</u> (4)				
4.0	QC8	SECOND CHECK  		
Comment: SECOND CHECK  <u>ml 06 11 30</u> (4)				
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  		
Comment: SMALL/MED FAB  1-Deburr sharp edges <u>SAD 06/12/02</u> (4) 2-Countersink holes per Dwg D2344 <u>ml 06/12/12</u> (4)				

Date: Tuesday, 21/11/2006 1:40:50 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 29143

Part Number: D2344

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>Feb-12-12 (4)</i>
7.0	POWDER COATING	POWDER COATING <i>M100700 (4)</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>M. A. Jan 07/01/03 (4)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>57171 (4)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE <i>10/01/05 (4)</i>

Job Completion



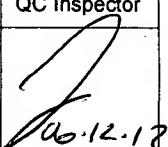
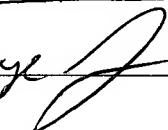
*10/01/05*

*10/01/05*

7.0

Acid: Alkaline AS per QSI 005 4.1

*JB 06-12-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.12.12	7.0	Added Attachment to QSI 005 4.1					
	7.1	Permanent change 		26.12.12			06.12.12

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/08  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:06:29 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LITTER DECKPLATE 350		
Job Number	: 29143						
Estimate Number	: 10357						
P.O. Number	:			Part Number	: D2344		
This Issue	: 10/24/2006	S.O. No.	:	Drawing Number	: D2344 REV.E		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: E		
Previous Run	: 25294			Material	:		
Written By	:			Due Date	: 11/6/2006	Qty:	4
Checked & Approved By	: <u>JK 06 10 24</u>			Um:	Each		
Comment	: Est Rev.D 00.06.26 Removed P/O for powder coat EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
		
		
	Comment: Qty.: 0.7823 sf(s)/Unit Total : 3.1290 sf(s)	<i>WJL</i>
	Material: 2024-T3 QQ-A-250(5) .063	
	Batch _____	
2.0	SHEAR	SHEAR
		
	Comment: Shear blanks: 17.100" X 6.380" +0.015/-0.000	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
	Comment: Haas #1	
	Machine per folio D2344 & dwg D2344	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL/MED FAB	
	1-Deburr sharp edges	
	2-Countersink holes per Dwg D2344	

DART AEROSPACE LTD		Work Order:	29143
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg:	D2344	Rev:	E

Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

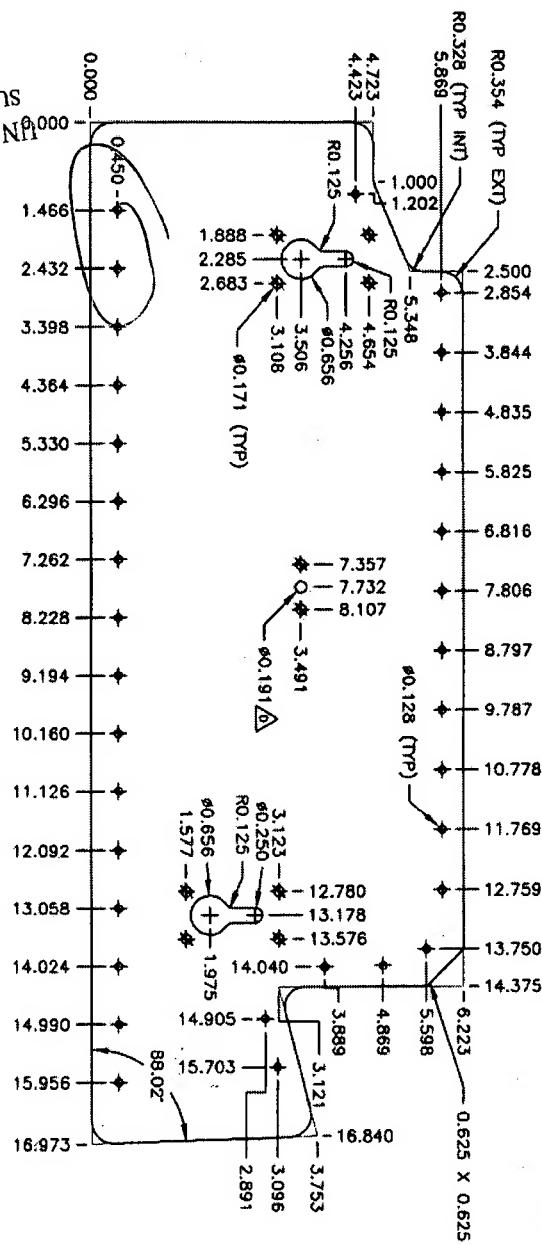
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.991	+/-0.005	0.990	✓		VERN	
6.223	+/-0.010	6.221	✓		VERN	
5.598	+/-0.010	5.598	✓		VERN	
4.869	+/-0.010	4.869	✓		VERN	
3.889	+/-0.010	3.890	✓		VERN	
3.096	+/-0.010	3.097	✓		VERN	
2.891	+/-0.010	2.895	✓		VERN	
16.973	+/-0.010	16.973	✓		Measuring tape	
0.966	+/-0.005	0.965	✓		VERN	
0.450	+/-0.010	0.453	✓		VERN	
4.423	+/-0.010	4.425	✓		VERN	
4.723	+/-0.010	4.726	✓		VERN	
1.202	+/-0.010	1.196	✓		VERN	
5.869	+/-0.010	5.869	✓		VERN	
4.654	+/-0.010	4.655	✓		VERN	
Ø0.656	+0.005/-0.000	0.656	✓		VERN	
1.888	+/-0.010	1.887	✓		VERN	
2.285	+/-0.010	2.289	✓		VERN	
2.683	+/-0.010	2.688	✓		VERN	
Ø0.171	+0.005/-0.000	0.171	✓		VERN	
0.750	+/-0.005	0.753	✓		VERN	
3.491	+/-0.010	3.495	✓		VERN	
Ø0.191	+0.005/-0.000	0.191	✓		VERN	
0.796	+/-0.005	0.795	✓		VERN	
3.123	+/-0.010	3.127	✓		VERN	
1.571.577	+/-0.010	1.580	✓		VERN	
1.975	+/-0.010	1.977	✓		VERN	

Measured by:	<i>MM</i>	Audited by:	<i>DL</i>	Prototype Approval:	N/A
Date:	06/11/30	Date:	06/11/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	<i>MM</i>

♦ COUNTER SINK HOLES:  
 C'SINK  $\phi 0.225 \times 100'$   
 ♦ C'SINK  $\phi 0.308 \times 100'$

NO. 29147  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 DYNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY  
 MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK  
 FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	K.E.	DRAWN BY	HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.	D2344
REV. E			SHEET 1 OF 1
SCALE		TITLE	LITTER DECK PLATE, 350
			98.06.19
			95.01.14 NEW ISSUE
			95.02.09 MOVED KEY HOLES
			95.03.06 0.191 WAS 0.197
			98.06.19 0.063-0.071 THICK WAS 0.071 (TSR A371)
			98.06.19 0.063-0.071 THICK WAS 0.071

RELEASED

